



Dart Aerospace Ltd.
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Canada

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D119-796-151
Job Sheet 170342-B



Part No: D119-796-151

Job Qty: 1 ea

Part Name: Fwd Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/15/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D119-796-151 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:D 15-02-11 AS PER REV D JLM VERIFIED BY:DD IPP REV:E 17.12.11 REMOVE PICK KIT DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/25/18	0.00	0.00	Start Up Crosstubes-1		AP FEB 11 2018
130	Crosstubes	1 pcs		1/26/18	0.00	0.49	Crosstubes-1	✓	AP FEB 11 2018
140	QC	1 pcs		1/26/18	0.00	0.00	QC5		38 FEB 12 2018
145	DC	1 pcs		1/26/18	0.00	0.00	DC		AP FEB 12 2018
150	Packaging	1 pcs		1/26/18	0.00	0.00	Packaging3-1		AP FEB 12 2018
160	QC21-FG	1 Ea		1/26/18	0.00	0.00	QC21		21 FEB 13 2018

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-151 ***Torque all clamps to 50 IN-LBS max.***
Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***

145 - Photocopy bluefile and create labels as per PPP D119-796-151 chg 00#5 AA
150 - Identify and pack for shipping as per PPP D119-796-151

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	168222 D119-796-141 5022077	①	6	0	0
	D5123-3 5006028	④	358	0	0
	D5149-041 5040195	②	1	0	0
	MS21920-22 5023763	④	130	0	0

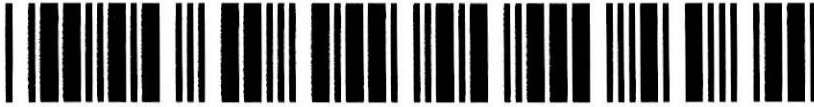
Part Specifications

Specifications could not be found.

Plex 1/15/18 11:13 AM Dart.lajeunesse.marie



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Fwd Crosstube Installation With Step (No Hardware)

PART NO: D119-796-151

Original Serial #: S041235

Revision:

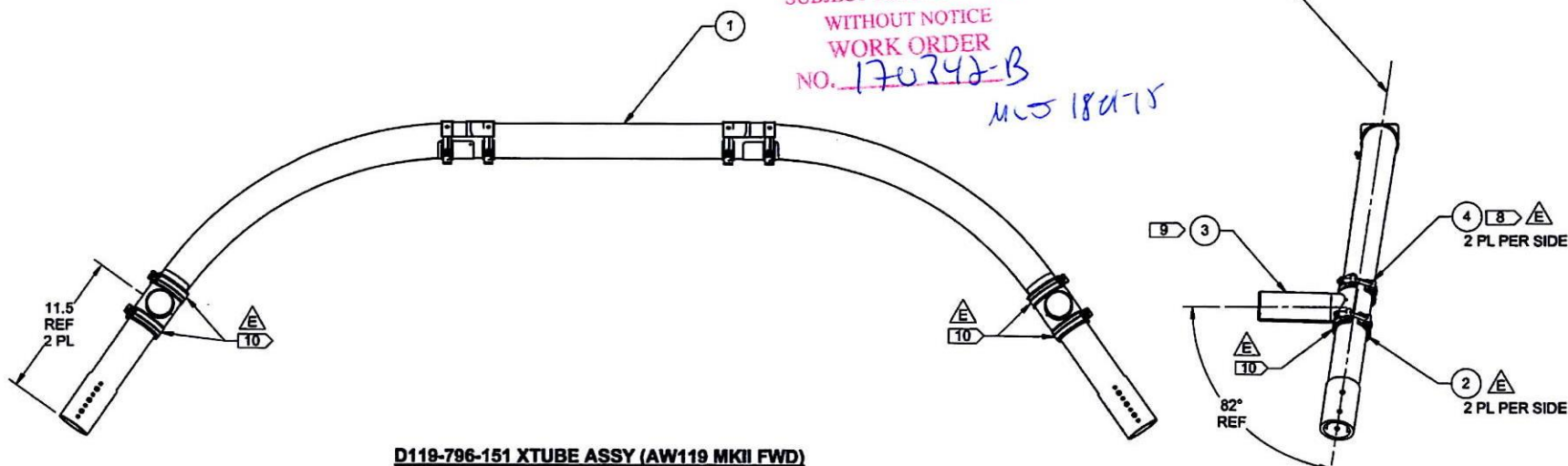
Operation: Start up Operation 02/12/18

Change No: CHG005

Job No: 170342-B

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170342-B
MCS 18015



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

NOTES:

- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
 - 7) WEIGHT: 20.01 lbs
 - 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
 - 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
 - 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN.
- THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

E	MODIFY CLAMP ORIENTATION, ADD NOTE 10 (PAR16-527) UPDATE WEIGHT DUE TO -141 CHANGE	ML	17.02.10
D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, ANMCA WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	DP	D119-796-151	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
DATE	17.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2017-05-04
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APPROVED